



Dart Aerospace Ltd.
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RBW6405G08632-3G
Job Sheet 196133



Part No: RBW6405G08632-3G

Job Qty: 1 pcs **2**

Part Name: AW139 Tail Rotor Bushing Removal/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16777

Note: DWG RBW6405G08632-3G Rev B IPP Rev.A 17.09.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Small Fab - Issue SN	1 pcs	6/28/19	0.00	0.00	0.00	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	6/28/19	0.00	0.33	0.33	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	6/28/19	0.00	0.00	0.00	QC 4 - 28		DAS 40 9-89
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
							QC 4 - 72		
							QC 4 - 74		
130	Packaging 3-1 - Stock - B4B	1 pcs	6/28/19	0.00	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		



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Container No: S188906



Part: RBW6405G08632-3G

Job No: 196133

Serial No/Batch: S188906

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 06/10/19

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					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	6/28/19	0.00 0.00		QC 21 - SA - 21	Dave
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-59

GA060F

Part Op 100 - Issue S/N

Descriptions: 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1200-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6405G08632-3G-13 to RBW6405G08632-3G-09 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

JUN 10 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - Issue SN	5163934
APP-1200-E	Case	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184356
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5021040
RBW6405G08632-3G-07	Bottom Tool Protector (Y-20, Black) use in case APP-1200-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184354
RBW6405G08632-3G-09	Top Tool Protector (Y-20, Black) use in case APP-1200-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184353
RBW6405G08632-3G-13	Inside Placard (Lasered)	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5137284
RBW6405G08732-3G-PO	Tail Rotor Bushing Removal Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5182427
RBW6405G08832-3G-PO	Tail Rotor Bushing Install Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5171589
				5138634

22010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Issue SN	97524A032	4	229	0
110-Small Fab - 2 - B4B	APP-1200-E	1	16	0
	RB41011	1	302	0
	RBW6405G08632-3G-07	1	4	0
	RBW6405G08632-3G-09	1	4	0
	RBW6405G08632-3G-13	1	3	0
	RBW6405G08732-3G	1	3	0
	RBW6405G08832-3G	1	3	0

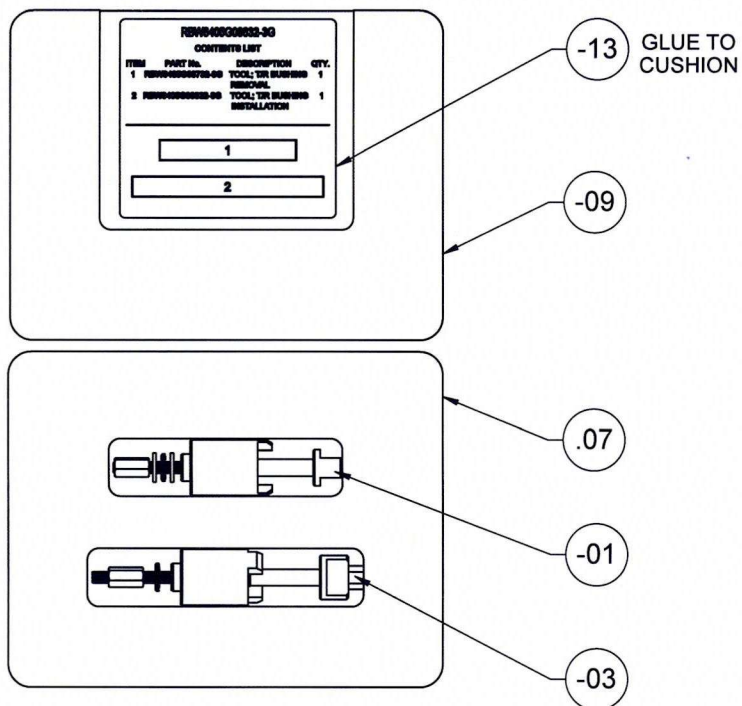
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	SEPERATED OUT FROM KIT	3/14/11	JAG	RW
B	-13 CH'D LETTERING COLOR WAS ALUMINUM IS WHITE. CH'D MATERIAL IN BOM WAS ALUMINUM IS PLASTIC. -9 CH'D MATERIAL WAS EPDM IS Y-20, BLACK.	3/12/13	BIM	RJC



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WORK ORDER

NO. 196133 MWS
1906-07

B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION	Pg
	-01	1	T/R BUSHING REMOVAL TOOL		T/N RBW6405G08732-3G	1
	-03	1	T/R BUSHING INSTALL TOOL		T/N RBW6405G08832-3G	1
B/O	-05	1	HARD CASE	PLASTIC	PELICAN #250P-1200-E	N/S
B/O	-07	1	BOTTOM TOOL PROTECTOR	Y-20; BLACK	3 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	2
B/O	-09	1	TOP TOOL PROTECTOR	Y-20, BLACK	1-3/16 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	3
B/O	-11	1	RB PLACARD, (on case top)	ALUMINUM	RB41009	N/S
B/O	-13	1	INSIDE PLACARD, (lasered)	PLASTIC	1/32 x 4-5/16 x 4-11/16	4

RED BARN MACHINE	
TITLE	
TAIL ROTOR BUSHING KIT	
DWG NO.	REV
RBW6405G08632-3G	B
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS .XXX ± .005	APPROVED
XX ± .01	HEAT TREAT
X ± .1	FINISH SPEC
METRIC .X ± .1mm	USED ON MODEL
FRACTIONS ± 1/32	AGUSTA
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	DATE
NTS	8-24-10
SHEET	1 of 4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date : _____	Sequence #: _____		QTY Affected : _____		MRB (QSI042) ☐
Description Work Order Deviation			Disposition		Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			